Side Sill (Outer panel)

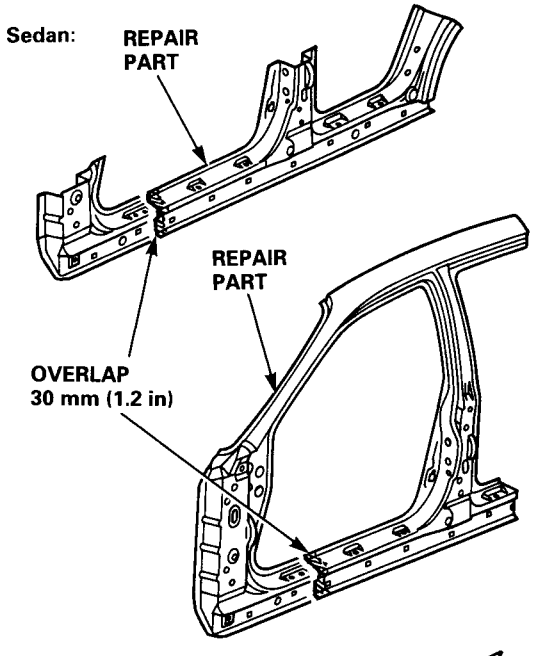
Replacement

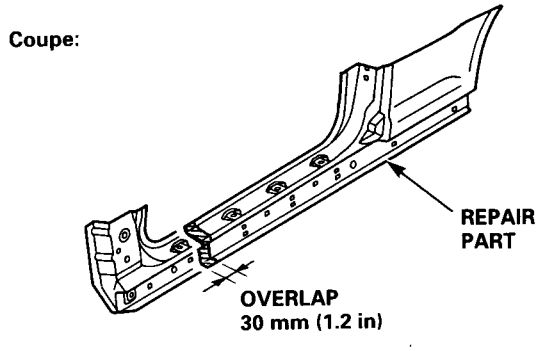
1. Remove the related parts.
   - Doors
     (remove according to part damaged)
   - Side trim panel
   - Door opening trim and side trim
   - Carpet
   - Door switch
   - Seat belt

2. Pull out and straighten the damaged area.
   Damage may extend to the inside sill and floor. Determine the extent of the damage first, so that the frame can be pulled out properly.

3. Cut and pry off the side sill
   - Check the damage on the outer side sill, then cut the repair outer side sill so it will overlap by 30 mm (1.2 in) in the front and back.
   - Cut the side sill with a handsaw.

   NOTE: Be careful not to cut the inside sill and center pillar stiffener. This could result in extensive repair.

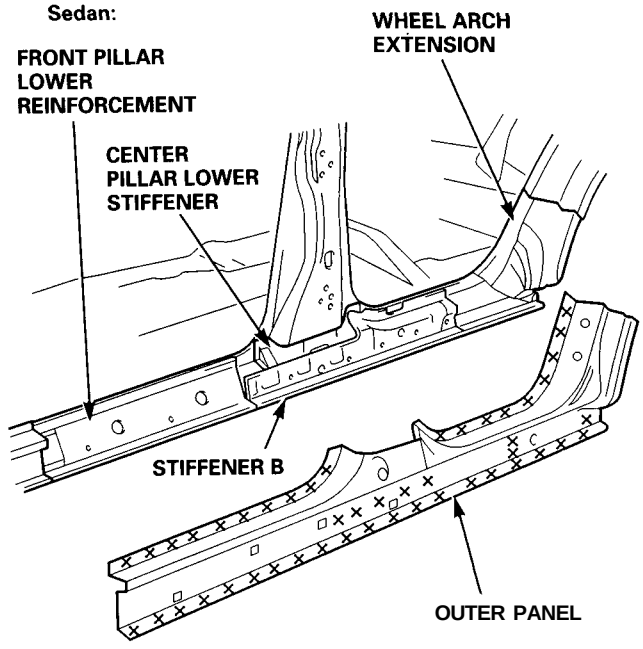


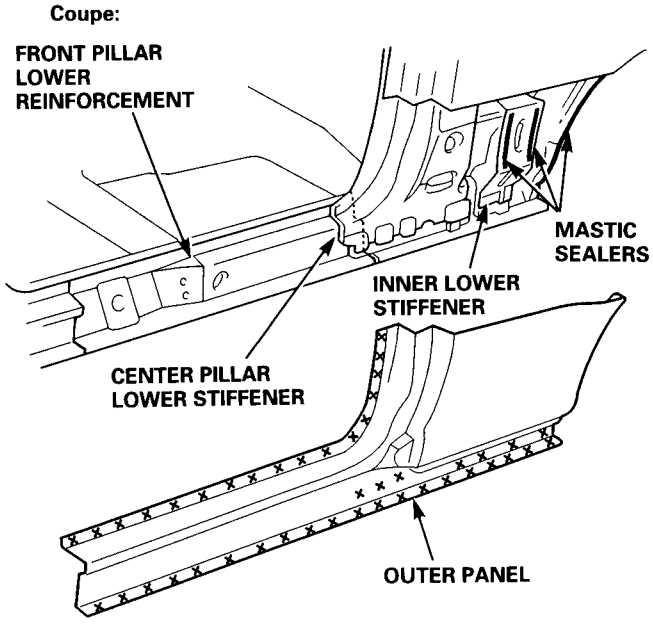


   - Center punch around the spot weld imprints on the welded flange.
   - Drill holes using the spot cutter.
   - Pry off the welded flange with a chisel.

   NOTE: Do not cut or damage the center pillar lower stiffener and inner lower stiffener (coupe).

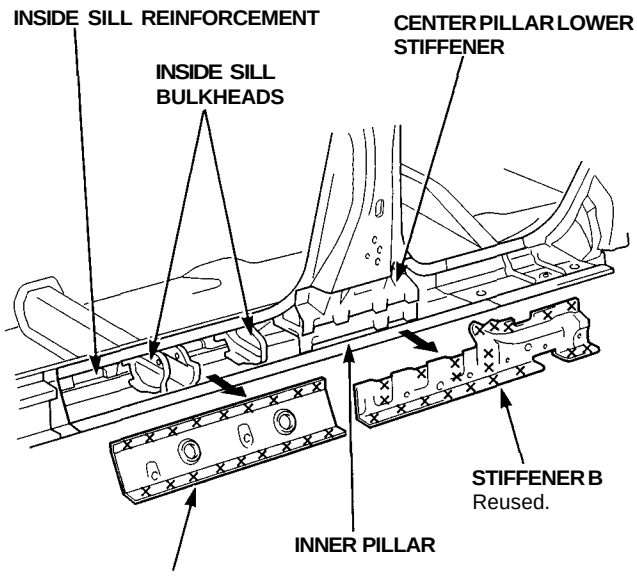
   - If the damage involves part of the center pillar and rear wheel arch, cut them as shown with a handsaw.





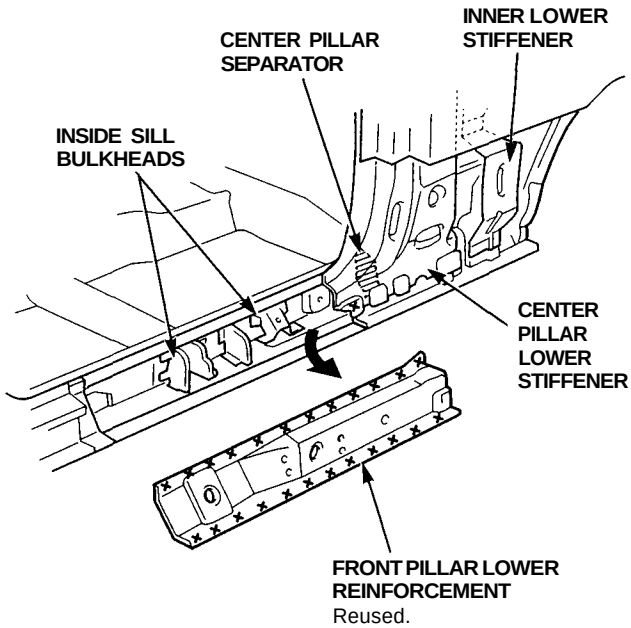
- Check the inside sill, center pillar lower stiffener, stiffener B (sedan), front pillar lower reinforcement, and inner pillar (sedan) or inner lower stiffener (coupe) for position and damage.
- Cut the front pillar lower reinforcement, and remove the stiffener B (sedan), if necessary.

Sedan:



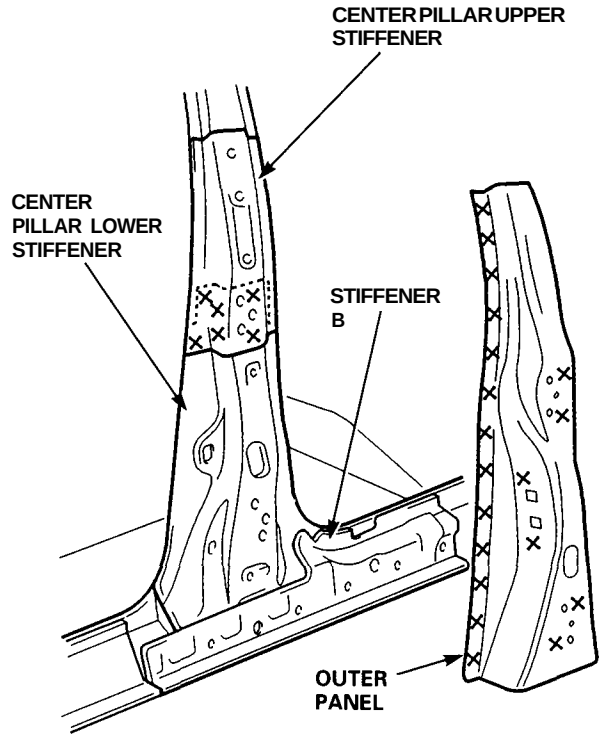
Coupe:

NOTE: Do not damage the center pillar separator.

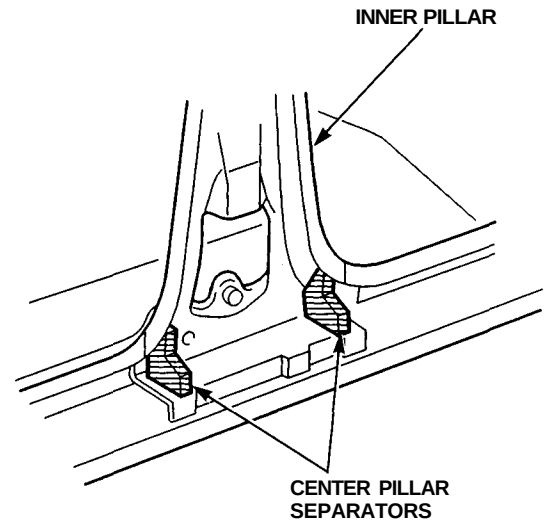


Sedan:

- When replacing the center pillar lower stiffener, and stiffener B as an assembly, cut the outer panel as shown with a handsaw.



- Remove the center pillar separators from the inner pillar.



(cont'd)

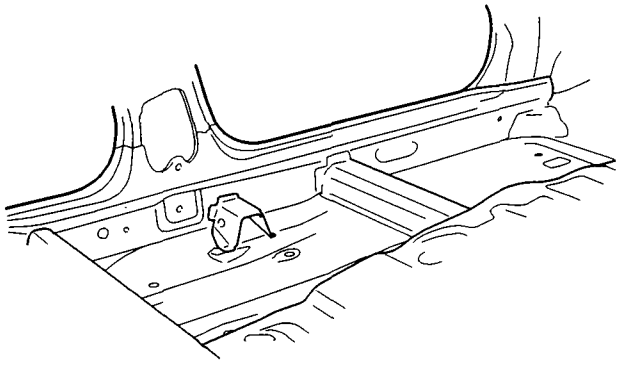
Side Sill (Outer Panel)

Replacement (cont'd)

4. Straighten the related parts.
   - Fill any holed areas by MIG or gas welding.

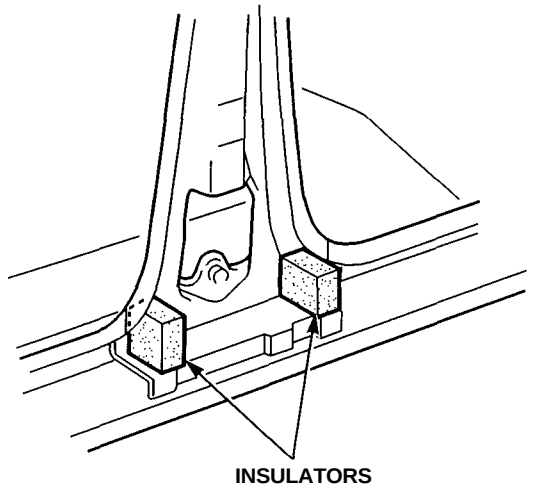
   ⚠WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

   - Level and finish burrs at welded areas with a disc sander, then even them out with a hammer and dolly.
   - Sand off the undercoat from both sides of the flange to be welded.



Sedan:

- Glue the insulators to the inner pillar at the center pillar separator mounted positions.
  Insulator: P/N. 74416-SF1-000
  Adhesive: Cemedine 366 or equivalent



5. Set the front pillar lower reinforcement and new center pillar lower stiffener (sedan).
   Sand off the undercoat from both sides of the welded flange with a sander to expose the steel plate.

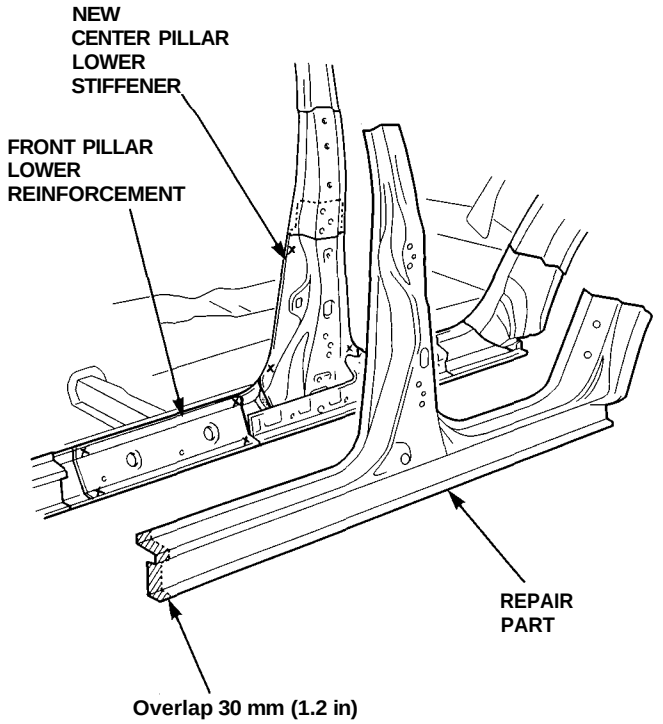
   NOTE: Apply the spot sealer to the welding surface when spot welding.

Sedan:

- Clamp the front pillar lower reinforcement and center pillar lower stiffener and check the position of them using the body dimensional drawings (see section 6).
- Tack weld the front pillar lower reinforcement and center pillar lower stiffener.

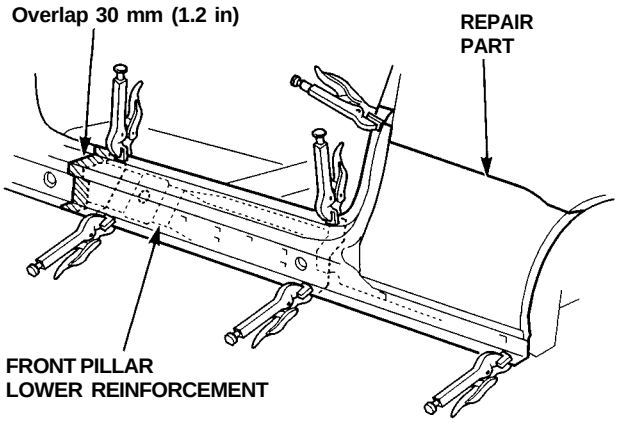
⚠WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

- Clamp the repair part and temporarily install the doors, and check the door hinge mounting positions.
- Remove the repair part.



Coupe:

- Clamp the front pillar lower reinforcement and repair part and check the position of them using the body dimensional drawings (see section 6).



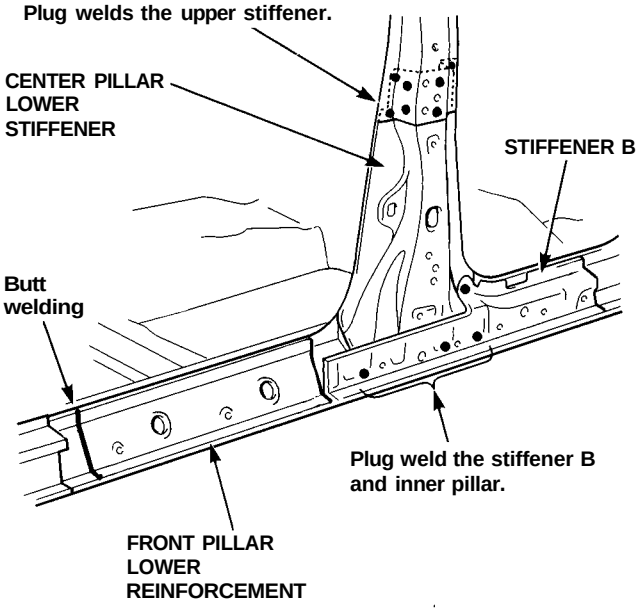
- Remove the repair parts.

6. Weld the front pillar lower reinforcement and center pillar lower stiffener.

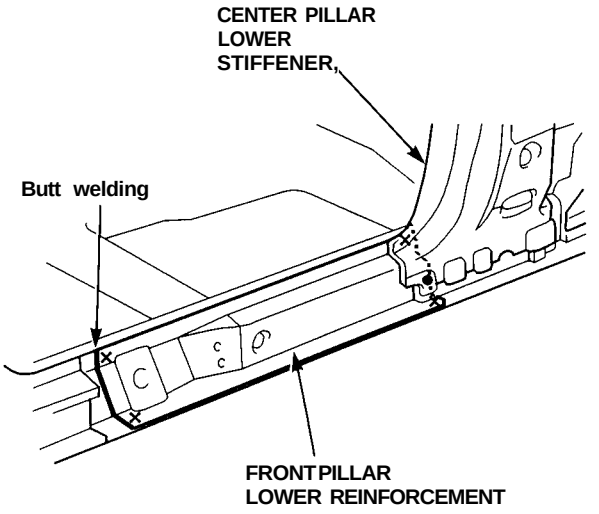
⚠WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

Sedan:

NOTE: Be careful not to burn the insulator of the fitting inside center pillar lower stiffener, while welding.


Plug welds the upper stiffener.
CENTER PILLAR LOWER STIFFENER
STIFFENER B
Butt welding
Plug weld the stiffener B and inner pillar.
FRONT PILLAR LOWER REINFORCEMENT

Coupe:



7. Set the repair part (outer panel).
   - Sand off the undercoat from both sides of the welded flange on the repair part.
   - Clamp the repair part in place with vise-grips.

   NOTE: Apply the spot sealer to the welding surface when spot welding.

   - Check the body dimensions (see section 6).

8. Tack weld the repair part.

⚠WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

- Remove the vise-grips and install the fender and doors. Check for differences in level and clearance.

(cont'd)

Side Sill (Outer Panel)

Replacement (cont'd)

9. Perform main welding.

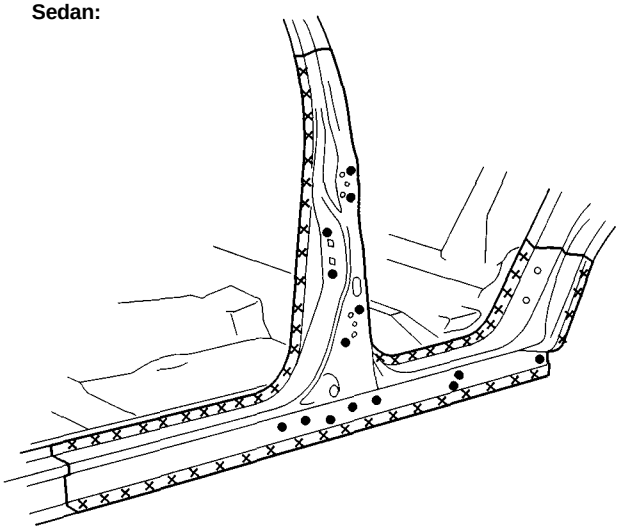
WARNING **To prevent eye injury and burns when welding, wear an approved welding helmet, gloves, and safety shoes.**

- Weld the side sill and rear side outer joints with *a* MIG welder.
- Spot weld the side sill flanges.
- Make 20% to 30% more spot welds than there were holes drilled.

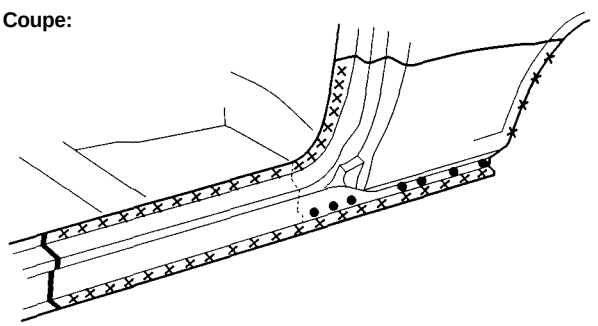
NOTE: If there isn't room for spot welds, compensate by using MIG welds.

- Make 5 mm (0.2 in) holes in the MIG weld holes with the repair part, and weld the center pillar lower stiffener, stiffener B (sedan) and inner panel with a MIG welder.

Sedan:



Coupe:



- Level the weld beads at the front and rear with *a* disc sander. Hammer down the projections, then fill with solder or putty to finish it.

10. Apply sealer to the mating surfaces of the floor and inside sill (see section 5).

11. Apply the paint. See Paint Repair section.

WARNING

- **Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.**
- **Avoid contact with skin. Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.**
- **Paint is flammable. Store it in a safe place, and keep it away from sparks, flames, or cigarettes.**

12. Apply the undercoat.
Undercoat the front floor, and apply an anti-rust agent to the inside of the side sill and center pillar (see section 7).

13. Install the related parts.
- Install in the reverse order of removal.
- Check the doors for proper installation and level differences from the fender.

14. Clean the passenger compartment and check for water leaks.